

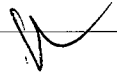
Work Order ID 84479

84479

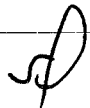
Page 1

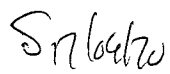
May-15-12 1:05:23 PM

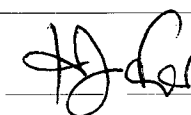
Item ID: D206-642-412 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube RH
 Start Date: 5/14/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/14/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference: rework - ECN09-531

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-642	O								
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D206-642-412 CHG006								





 MLS 12-6-7

Work Order ID 84479

84479

Page 2

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Item ID: D206-642-412 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube RH
 Start Date: 5/14/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 5/14/12 Req'd Qty: 1.00 *1* Customer:
 Reference: rework - ECN09-531

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

101

0.00

101

HandFinish

Hand Finishing

Memo

PULL FROM HK:
 1 X D206-642-411 B34564
 UPDATE TO CHG006 PER ECN08-538 & 09-531 DSI9421/9440

REMOVE WEARPLATES:

6 X D2648-3 B33059
 1 X D2656-15 B34170
 1 X D2656-23 B34171
 1 X D2656-37 B33217
 1 X D3429-1 B34012
 RETURN TO STK
 DISCARD HARDWARE

ADD:

6 X D3537-1 B _____
 1 X D3537-3 B _____
 1 X D3535-15 B _____
 1 X D3536-15 B _____
 1 X D3535-23 B _____
 1 X D3536-23 B _____
 1 X D3535-37 B _____
 1 X D3536-37 B _____
 60 X MS27039C1-08 B _____
 60 X AN960C10L (NAS1149C0332R)
 B _____

1 ϕ BR126-5.

DART		TEL: 1-613-632-3336 FAX: 1-613-632-4448	
TRANSPORT CANADA APPROVAL # 09-89			
P/N	D206-642-412	CHG	CHG004
DESC	Skidtube RH High	STC	SH98-4
LOT	B34564	STC	SA00475SE
MODEL	Bell 206L/L1/L3/L4	STC	
US PATENT # 5,735,488 CANADA FOREIGN PATENTS PENDING		MADE IN CANADA	

Work Order ID 84479***84479***

Page 3

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Item ID: D206-642-412

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH

Start Date: 5/14/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/14/12 Req'd Qty: 1.00

1

Customer:

Reference: rework - ECN09-531

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

105

QC5- Inspect part completeness to step on W/O

0.00

105

QC

Memo

0.00

Quality Control

5/17/12

Work Order ID 84479

84479

Page 4

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Item ID: D206-642-412 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube RH
 Start Date: 5/14/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 5/14/12 Req'd Qty: 1.00 *1* Customer:
 Reference: rework - ECN09-531

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--

110

Packaging

Packaging

Memo

0.00

REMOVE FROM KIT TO UPDATE TO CHG006:

1 X D2707-043(OR D2968-043)-SCRAP

1 X AN960JD1016 B 104746 30275

1 X AN970-4 B 104746 30275

1 X MS21042-4 B 104746 30275

1 X AN4-5A B 104746 30275

1 X AN960JD416 B 104746 30275

1 X D2655 B 32988 30275

RETURN TO STK

ADD TO KIT:

1 X D3407-043 B

1 X D3456-1 B 81976

2 X D3457-1 B 81977

1 X MS21043-4 B 121162

1 X AN4C5A B 119017

1 X AN960C416 B 119097

1 X D3413-1 B 83302

12/6/75

Work Order ID 84479

84479

Page 5

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Item ID: D206-642-412 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube RH
 Start Date: 5/14/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 5/14/12 Req'd Qty: 1.00 *1* Customer:
 Reference: rework - ECN09-531

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							
130 *130* Packaging Packaging	Packaging Memo REPACKAGE USING NEW B/N NEW LABELS AND PAPERWORK REQ'D Identify and pack for shipping as per PPP D206-642-412 Location: <u>40E</u> PPP Rev: <u>3</u>	0.00 0.00						12/6/2012	
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						12/6/22	

MR
12-06-21

Picklist Print

May-15-12 1:05:22 PM

Page 1

Work Order ID: 84479

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:K05.10.11Revised picklist per CHG004KJ/CP/JLM
IPP Rev:L 07-12-05 ECN 1080p DD verified by:ec
IPP Rev:M 08-09-29 as per DSI9421 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-5A Bolt		Purchased	No				Each	974.0000		-1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST355		974							
				120562		974							
S AN4C5A BOLT		Purchased	No				Each	199.0000		1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST355		199							
				112243		139							
				119017		60							
S AN960C416 washer	NAS1149C0463R	Purchased	No				Each	0.0000		1			
AN960JD1016 Washer	NAS1149C1063R	Purchased	No				Each	369.0000		-1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		369							
				5519		369							
AN960JD416 Washer	NAS1149D0463J	Purchased	No				Each	30.0000		-1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		30							
				116289		10							
				119097		20							

M100852

1

M119697

M1047465

12/6/12

D2968 073 B30275

Picklist Print

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Page 2

Work Order ID: 84479

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

AN970-4 Purchased No Each 203.0000

-1

m104885

Location	Loc Qty	Loc Code
ST344	203	
115936	11	
120308	3	
120644	30	
121285	159	

D206-642-412 Manufactured No Each 2.0000

1

B384479

Location	Loc Qty	Loc Code
FG081	1	
78487	1	
FG082	1	
41319	1	

D2648-3 Manufactured No Each 9.0000

-6

BL 12-6-4

Location	Loc Qty	Loc Code
ST <i>33059</i>	-10	
81513	9	
ST237A	19	

6

D2655 Ring Manufactured No Each 30.0000

-1

B320988
6/6/7

Location	Loc Qty	Loc Code
ST464	30	
44295	15	
45738	15	

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Shop Packet Print

Page 2

Picklist Print

May-15-12 1:05:22 PM

Page 3

Work Order ID: 84479
Parent Item: D206-642-412
Parent Item Name: Skidtube RH

Start Date: 5/14/12
Start Qty: 1.00

Required Date: 5/14/12
Required Qty: 1.00

D2656-15	Manufactured	No	Each	6.0000	-1	BR 126-4
Wearshoe						
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
		FP 34176.	5		1	
		83601	5			
		Mezz	1			
		51455	1			
D2656-23	Manufactured	No	Each	9.0000	-1	BR 126-4
Wearshoe						
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
		Mezz 34171.	9		1	
		43407	2			
		51468	7			
D2656-37	Manufactured	No	Each	21.0000	-1	BR 126-4
Wearshoe						
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
		Mezz 33017.	21		1	
		34510	2			
		44550	7			
		46497	1			
		53019	11			
D3407-043	Manufactured	No	Each	14.0000	1	BR 85525 5 u
Tow Ring						
		<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
		ST420	1			
		79232	1			
		ST463	13			
		68339	2			
		77504	10			
		78841	1			

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Shop Packet Print

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Picklist Print

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Page 4

Work Order ID: 84479
Parent Item: D206-642-412
Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

S D3413-1 Ring Manufactured No Each 73.0000

1 SP

Location	Loc Qty	Loc Code
ST420	4	
79233	4	
ST464	69	
76754	1	
80224	7	
83307	41	
83867	20	

D3429-1 Wearpad Manufactured No Each 16.0000

-1 BR12-6-H.

Location	Loc Qty	Loc Code
FP002 34012.	16	
40438	2	
43706	1	
44579	12	
65692	1	

S D3456-1 Washer Manufactured No Each 168.0000

1 12/6/7 SP

Location	Loc Qty	Loc Code
FG	7	
25701	7	
ST044	161	
80252	1	
81876	60	
83584	100	

Picklist Print

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Page 5

Work Order ID: 84479
Parent Item: D206-642-412
Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D3457-1 Washer Manufactured No Each 35.0000

2

50

Location	Loc Qty	Loc Code
FG	10	
32409	10	
ST044	25	
67779	1	
81977	24	

D3535-15 Wearshoe Manufactured No Each 17.0000

1

BR 12-6-5

Location	Loc Qty	Loc Code
FP001	17	
80328	4	
81354	13	

D3535-23 Wearshoe Manufactured No Each 22.0000

1

BR 12-6-5

Location	Loc Qty	Loc Code
FP001	22	
81355	2	
83375	20	

D3535-37 Wearshoe Manufactured No Each 4.0000

1

BR 12-6-5

Location	Loc Qty	Loc Code
FP001	4	
84807	4	
71668	4	

D3536-15 Gasket Manufactured No Each 20.0000

1

BR 12-6-5

Location	Loc Qty	Loc Code
FP002	20	
73318	14	
81343	6	

Picklist Print

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Work Order ID: 84479

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D3536-23 Manufactured No Each 16.0000
Gasket

1 BR 12-6-5.

Location	Loc Qty	Loc Code
FP002	16	
74510	1	
83377 ✓	15	

D3536-37 Manufactured No Each 19.0000
Gasket

1 BR 12-6-5.

Location	Loc Qty	Loc Code
FP002	19	
66823	7	
82623 ✓	12	

D3537-1 Manufactured No Each 41.0000
Wearpad

6 BR 12-6-5.

Location	Loc Qty	Loc Code
FG 84091.	10	
79833	10	
FP002	31	
69817	5	
81362	22	
83254	1	
83255	3	

D3537-3 Manufactured No Each 28.0000
Wearpad

1 BR 12-6-5.

Location	Loc Qty	Loc Code
FP002	28	
78836	5	
81363 ✓	23	

Picklist Print

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Page 7

Work Order ID: 84479
Parent Item: D206-642-412
Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

MS21042-4 Purchased No Each 1,071.0000

-1

11/04/683 SD

USE MS21042L4

Location	Loc Qty	Loc Code
ST299	1071	
100743	9	
119124	1000	
5461	1	
6844	19	
7690	24	
8182	6	
9063	8	
9229	4	

MS21043-4 Purchased No Each 1,546.0000

1

12/6/7 SD

Nut

Location	Loc Qty	Loc Code
FG	40	
104603	40	
ST301	1506	
119546	185	
121162	821	
121652	500	

MS27039C1-08 Purchased No Each 1,142.0000

60

BR 12.6-5

SCREW

Location	Loc Qty	Loc Code
FP002	1	
116022	1	
ST292	1122	
120308 ✓	354	
121068	108	
121162	660	
ST293	19	
116373	3	
118077	14	
119309	2	

60.

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Shop Packet Print

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Picklist Print

May-15-12 1:05:22 PM

Page 8

Work Order ID: 84479

Parent Item: D206-642-412

Parent Item Name: Skidtube RH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

Each 3,354.0000

60

12-6-5.

Washer

Location

Loc Qty

Loc Code

ST297

219

119736

196

120648

23

ST298

3135

121255

11

121509 ✓

3124

60.

May-15-12 1:05:22 PM

Shop Packet Print

Page 8

412

Dart Aerospace Ltd.

40

Date: Wednesday, 9/12/2007 11:54:06 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 L HIGH GEAR SKIDTUBE
 Job Number : 34564A
 Estimate Number : 10522
 P.O. Number : N/A Part Number : D206642441
 This Issue : 9/12/2007 S.O. No. : N/A Drawing Number : D2650 REV E
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : E
 Previous Run : 34563A Material : N/A
 Written By : Due Date : 10/5/2007 Qty: 1 Um: Each
 Checked & Approved By : 07-09-12
 Comment : Est Rev: H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JL
 M

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A

2.0 D2620 Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D2620 Bent Tube 3" OD 34692

7-9-24

3.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D2647 Fwd Cap 29328

BE 07-09-24

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod M 104221 BE 07-09-24

4-Grind weld flush to cap on top surface only.

BE 07-09-24

Date: Wednesday, 9/12/2007 11:54:06 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34564A

Part Number: D206642441

Jeb Number:



Seq. #:

Machine Or Operation:

Description:

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

7-9-25

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



AWM
07/09/26



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

6.0

D26547

206 L Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-7

Web

B-34594

AWM
07/09/26

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting

Start Date: 07/09/26 Time: 11:05

Finish Date: Time:

A/R Sikaflex-291

Sikaflex expiry date:

M105586
07/07/01

AWM/R
07/09/26

Date: Wednesday, 9/12/2007 11:54:06 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34564A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

CP 12/09/06

9.0

D2649

Crossbolt Spacer



Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

23 D2649

Crossbolt spacer

B33214 BE 07-09-27

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod M105138 BE 07-09-27

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Debur

DP 7-10-2

11.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2680-041

Nut Plate

B30446

DP 7-10-2

12.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 CCR264SS3-3

Rivets

103525

DP 7-10-2

13.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

Date: Wednesday, 9/12/2007 11:54:06 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34564A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

2 M7885/3-4-3

Rivets

102515

DP

7-10-2

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

DP

7-10-2

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

DP 07-10-02

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/10/03

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(IX)

Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M-H

07/10/03

18.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3

Make sure Nut Plate Thread protected use paint screw

M105068

HI 04-10-04

①

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 07-10-04

20.0

D26483

Wearpad



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 D2648-3

Wearpad

33059

BR

21.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-15

Wearshoe

334170

BL

BR 07-10-04

Form: mprocess

Date: Wednesday, 9/12/2007 11:54:06 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34564A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D265623

Wearplate

1



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-23

Wearshoe

B34171

BR

23.0

D265637

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-37

Wearshoe

B33217

BR

24.0

D34291



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad

B34112

BR

25.0

ALS41032130

Insert



Comment: Qty.: 60.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 ALS4-1032-130

Inserts

M105709

or (see QSI 017)

BR

26.0

AN960JD10L

Washer



Comment: Qty.: 60.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 AN960JD10L

Washer

M104885

BR

BR 07-10-04

Date: Wednesday, 9/12/2007 11:54:06 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34564A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

MS27039108

Screw



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 MS27039-1-08

Screw

m105433

BR

28.0

D26511

Plug



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-1

Plugs

B33349

BR

29.0

D26513

O-Ring



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-3

O-Rings

B33452

BR

30.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer

m10338

BR

31.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS27039-4-06

Screw

m15194

BR

32.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

B33289

BR

Date: Wednesday, 9/12/2007 11:54:06 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 34564A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D2646

Aft Cap

33.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN960JD10L

Washer

M 104885

BR

34.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS27039-1-08

Screw

M 105433

BR

35.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

M 105469

Sikaflex expiry date:

08-01

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650.
Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291

M 105469

Sikaflex expiry date:

08-01

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch: M 105694

M 07-10-09 (D)

BR 07-10-04

40

Date: Wednesday, 9/12/2007 11:53:33 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L/L3/L4 HIGH GEAR SKID
 Job Number : 34564
 Estimate Number : 10526
 P.O. Number : N/A Part Number : D206642412
 This Issue : 9/12/2007 S.O. No. : N/A Drawing Number : N/A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : N/A
 Previous Run : 34563 Material : N/A
 Written By : Due Date : 10/5/2007 Qty: 1 Um: Each
 Checked & Approved By : 07.09.12
 Comment : Est Rev:K 05.10.11 Revised picklist per CHG004 KJ/CP/JL
 M

Additional Product

Job Number:



Seq. # Machine Or Operation: Description:

10 DC DOCUMENT CONTROL



KS 07-09-13

Comment: DOCUMENT CONTROL

Photocopy clients and create labels per PPP D206-642-412 CHG004

Er 07/10/10

20 34564A 206 L HIGH GEAR SKIDTUBE

Er



Comment: SUB-Component 206 L HIGH GEAR SKIDTUBE

D206-642-412 34564A

CP

30 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packaging Kit

40 D2065 Flushing



Comment: Qty: 24.0000 Each(s) Total: 24.0000 Each(s)

Pick Flushing Kit

Qty	Part Number	Description	Batch
24	D2065	Bushing	33350
1	D206-642-412 (REF)		

CP

50 D2655 Ring



Comment: Qty: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick Flushing Kit

Qty	Part Number	Description	Batch
1	D2655	Tow Ring	332988

CP

Er 07/10/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ DCR # _____ Fault Category: _____ NCR: Yes (X) No () BQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 11:53:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Cart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 34564

Part Number: D206642412

Job Number:



Seq. # Machine Operation Description:

6 D2659 Wing Assembly



Component: Qty: 2,000 Each(s) Unit: Total: 2,000 Each(s)

Pick: Picking

Qty Part Number: Description: Batch:

2 D2659 Wing Assembly 334076

7 D2712 Wing Screw



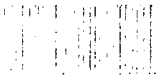
Component: Qty: 10,000 Each(s) Unit: Total: 10,000 Each(s)

Pick: Picking

Qty Part Number: Description: Batch:

10 D2712 Wing Screw 334122

8 D2652 Wing Saddle Right side



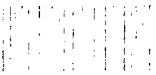
Component: Qty: 1,000 Each(s) Unit: Total: 1,000 Each(s)

Pick: Picking

Qty Part Number: Description: Batch:

1 D2652 Wing Saddle 334064

9 D2652 Wing Saddle Left side



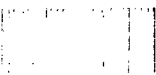
Component: Qty: 1,000 Each(s) Unit: Total: 1,000 Each(s)

Pick: Picking

Qty Part Number: Description: Batch:

1 D2652 Wing Saddle 333008

10 D2652 Wing Saddle Spacer



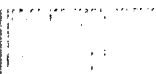
Component: Qty: 2,000 Each(s) Unit: Total: 2,000 Each(s)

Pick: Picking

Qty Part Number: Description: Batch:

2 D2652 Wing Saddle 331173

11 D2652 Wing Saddle Spacer



Component: Qty: 2,000 Each(s) Unit: Total: 2,000 Each(s)

Pick: Picking

Qty Part Number: Description: Batch:

2 D2652 Wing Saddle 634123

6/7/10/100

Date: Wednesday, 9/2/07 11:53:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Cart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 34564

Part Number: D206642412

Job Number:



Seq. #:

Machine Or Operation:

Description:

12

D2938

06 Saddle Right Side



[Handwritten signature]



Comment: Qty: 1.000 Each(s) Total: 1.000 Each(s)

Pick: 1.000

Qty Part Number

Description Batch

1.000

Saddle

34678

13

D2939

06 Saddle Right Side



[Handwritten signature]



Comment: Qty: 1.000 Each(s) Total: 1.000 Each(s)

Pick: 1.000

Qty Part Number

Description Batch

1.000

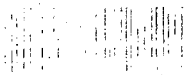
Saddle

33669

14

D2939

06 Ring



[Handwritten signature]



Comment: Qty: 1.000 Each(s) Total: 1.000 Each(s)

Pick: 1.000

Qty Part Number

Description Batch

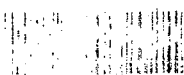
1.000

Track Ring

33675

15

AN277A



[Handwritten signature]



Comment: Qty: 1.000 Each(s) Total: 1.000 Each(s)

Pick: 1.000

Qty Part Number

Description Batch

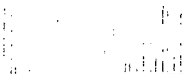
4

Bolt

110362

16

AN277A



[Handwritten signature]



Comment: Qty: 1.000 Each(s) Total: 1.000 Each(s)

Pick: 1.000

Qty Part Number

Description Batch

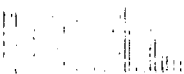
8

Bolt

1104625

17

AN277A



[Handwritten signature]



Comment: Qty: 1.000 Each(s) Total: 1.000 Each(s)

Pick: 1.000

Qty Part Number

Description Batch

1100857

[Handwritten signature]

Date: Wednesday, 9/12/2007 11:53:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 34564

Part Number: D206642412

Job Number:



Seq. #:

Machine Or Operation:

Description:

1 AN4-5A Bolt

18.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

12 AN4-6A

Bolt

M105057

19.0

AN511A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN5-11A

Bolt

M104936

20.0

AN512A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN5-12A

Bolt

M104885

21.0

AN513A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN5-13A

Bolt

M15928

22.0

AN960JD10

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

12 AN960JD10

Washer

M100151

Handwritten signature and date: 9/10/07

Date: Wednesday, 9/12/2007 11:53:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 34564

Part Number: D206642412

Job Number:



Seq. #:

Machine Or Operation:

Description:

23.0

AN960JD1016

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Qty Part Number Description Batch

1 AN960JD1016 Washer M15519

24.0

AN960JD416

Washer



Comment: Qty.: 25.0000 Each(s)/Unit Total: 25.0000 Each(s)

Qty Part Number Description Batch

25 AN960JD416 Washer M104746

25.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Qty Part Number Description Batch

8 AN960JD516 Washer M104156

26.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Qty Part Number Description Batch

1 AN970-4 Washer M104885

27.0

MS21042L3

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Qty Part Number Description Batch

12 MS21042L3 Nut (or -3) M104625

28.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total: 13.0000 Each(s)

Qty Part Number Description Batch

13 MS21042L4 Nut (or -4) M104683

CP 07/10/10 @

Date: Wednesday, 9/12/2007 11:53:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 34564

Part Number: D206642412

Job Number:



Seq. #:

Machine Or Operation:

Description:

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

E 07/10/10

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-412

Location:

PPP Rev:

E 07/10/10 @

31.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

D 07/10/11

Job Completion



U 07/10/10

B34564A

Part Number D206-642-412
Description 206 SKIDSTEER INSTALLATION

Part Number D206-642-412

Description	206 SKIDTUBE INSTALLATION
-------------	---------------------------

H:\admin-qalisof\forms\Change Record A

Rev. A

ENGINEERING CHANGE NOTICE
DART AEROSPACE LTD

Date: 09.02.18	Job No.: 00569	ADR Yes/No: N	ADR Date:	ECN #: 09- 531
Product No.: D206-642	Created By: AJS	Approved By:		
Product Name: Skidbe Installation	Checked By:	General Manager Approval:		

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL	11/09/02/19
Production Engineering Coord	Y	EC/DD	11/09/02/19
Production Document Control	Y	JLD	348 09.02.19
Customer Technical Support			

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord			
QC Coordinator	Y	JM	105-02-19
Marketing	Y	SW	820 09.03.16
Customer Order Processing			

Reason for Change: DESIGN IMPROVEMENT CHANGE FROM CARBON STEEL TO STAINLESS STEEL

Documents Affected:
DSI 9421 REV B
DSI 9440 REV A
D206-648 REV B
D3414 Rev B

PARTS MUST COMPLY ☐ **PREVIOUS PARTS SATISFACTORY** ☒

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	Y	KJ		09.02.19
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		09.02.19
9	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ		09.02.19
10	Update Controlled PDF Files	Y	KJ		09.02.19
11	Update Master Document List (MDL)	Y	AJS	Rev. U	09.02.19
12	Update Document Record (DR)	Y	KJ		09.02.19
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	N			
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	Y	KJ	SEE BELOW	09.02.19
18	Create / Update PPP's	Y	KJ		09.02.19
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	Y	KJ		09.02.19
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		09.02.19
22					
23					

Description / Action:
Roll -111/-112/-211/-212/-213/-214 to Change number 005 (Per DSI 9421)
-141/-241 @ CHG 004, -143/-243 @ CHG 002 (PER DSI 9440 Rev. A)
Roll -311/-312/-411/-412 To Change number 006 (Per DSI 9421)
-341/-441 @ CHG 003, -443 @ CHG 002 (PER DSI 9440 Rev. A)
Previous parts Disposition: Depelete existing stock of -111/-112/-211/-212/-213/-214 parts @ Change 004 repectively. DO NOT mix parts from change 004 and change 005

Previous parts Disposition: Depelete existing stock of -311/-312/-411/-412 parts @ Change 005 DO NOT mix parts from change 005 and change 006
D206-648-011/-013 NOW AT CHG002 (D206-648 Rev. B) -DO NOT MIX PARTS

ECN Verified & Complete: 

Date: 09/03/16

ENGINEERING CHANGE NOTICE **DART AEROSPACE LTD**

Date: 09.02.18	Job No: 00569	ADR Yes/No: N	ADR Date:	ECN #: 09- 531
Product No.: D206-642	Created By: AJS	Approved By:		
Product Name: Skidbe Installation	Checked By:	General Manager Approval:		

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL	
Production Engineering Coord	Y	EC/DD	11/02/19
Production Document Control	Y	JLD	09.02.19
Customer Technical Support			

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord			
QC Coordinator	Y	JM	09.02.19
Marketing	Y	SW	
Customer Order Processing			

Reason for Change: DESIGN IMPROVEMENT CHANGE FROM CARBON STEEL TO STAINLESS STEEL

Documents Affected:
 DSI 9421 REV B
 DSI 9440 REV A
 D206-648 REV B
 D3414 Rev B

PARTS MUST COMPLY ☐ PREVIOUS PARTS SATISFACTORY ☒

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	Y	KJ		09.02.19
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		09.02.19
9	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ		09.02.19
10	Update Controlled PDF Files	Y	KJ		09.02.19
11	Update Master Document List (MDL)	Y	AJS	Rev. U	09.02.19
12	Update Document Record (DR)	Y	KJ		09.02.19
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	N			
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	Y	KJ	SEE BELOW	09.02.19
18	Create / Update PPP's	Y	KJ		09.02.19
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	Y	KJ		09.02.19
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		09.02.19
22					
23					

Description / Action:

Roll -111/-112/-211/-212/-213/-214 to Change number 005 (Per DSI 9421)
 -141/-241 @ CHG 004, -143/-243 @ CHG 002 (PER DSI 9440 Rev. A)

Roll -311/-312/-411/-412 To Change number 006 (Per DSI 9421)
 -341/-441 @ CHG 003, -443 @ CHG 001, 343 @ CHG 002 (PER DSI 9440 Rev. A)

Previous parts Disposition: Depelete existing stock of -111/-112/-211/-212/-213/-214 parts @ Change 004 repectively. DO NOT mix parts from change 004 and change 005

Previous parts Disposition: Depelete existing stock of -311/-312/-411/-412 parts @ Change 005 DO NOT mix parts from change 005 and change 006

D206-648-011/-013 NOW AT CHG002 (D206-648 Rev. B) -DO NOT MIX PARTS

N/A
JW 09.03.03

ECN Verified & Complete: _____ Date: _____

4.4 206L/L-1/L-3/L-4 High Gear Skidtubes (D206-642)
32.13 206L/L-1/L-3/L-4 High Gear Skidtubes (ICA-D206-642)

IS:

ITEM	Qty -411	Qty -412	Qty -441	Qty -443	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-443	WEARSHOE KIT
	1	1			X	D206-648-013	GROUND HANDLING KIT
30	1	1				D3407-043	TOW RING ASSEMBLY
32A	1	1				D3456-1	WASHER
32B	2	2				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING
40					2	D3414-041	LUG ASSEMBLY
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

WAS:

ITEM	Qty -411	Qty -412	Qty -441	Qty -443	Qty -011	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-443	WEARSHOE KIT
	1	1			X	D206-648-011	GROUND HANDLING KIT
30	1	1				D2707-043 (OR D2968-043)	TOW RING
31	1	1				AN960JD1016	WASHER
32	1	1				AN970-4	WASHER
33	1	1				MS21042-4	NUT (OR MS21042L4)
34	1	1				AN4-5A	BOLT
35	1	1				AN960JD416	WASHER
36	1	1				D2655	RING
40					2	D2659	GHW LUG
41					4	AN3-37A	BOLT
42					8	D2652	BUSHING
43					4	MS21042-3	NUT (OR MS21042L3)
44					4	AN960DJ10	WASHER

DESIGN	AJS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9421	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE INSTALLATIONS	NTS
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4.3 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skidtubes (D206-642)
32.12 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skidtubes (ICA-D206-642)

ITEM	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT

IS:

20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)	(MODIFY)
22B			1	1		D3536-11	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)	(MODIFY)
24B			1	1		D3536-35	GASKET	(ADD)
26A			54			MS27039-1C08	SCREW	(MODIFY)
26B			54			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-11	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-35	WEARSHOE
26A			54			MS27039-1-08	SCREW
26B			54			AN960JD10L	WASHER

4.4 206L/L-1/L-3/L-4 High Gear Skidtubes (D206-642)
32.13 206L/L-1/L-3/L-4 High Gear Skidtubes (ICA-D206-642)

ITEM	Qty -411	Qty -412	Qty -441	Qty -447	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-447	WEARSHOE KIT (REPLACES -443)
	1	1			X	D206-648-013	GROUND HANDLING KIT

IS:

20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-15	WEARSHOE (REPLACES D2656-15)	(MODIFY)
22B			1	1		D3536-15	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-37	WEARSHOE (REPLACES D2656-37)	(MODIFY)
24B			1	1		D3536-37	GASKET	(ADD)
26A			60			MS27039-1C08	SCREW	(MODIFY)
26B			60			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-15	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-37	WEARSHOE
26A			60			MS27039-1-08	SCREW
26B			60			AN960JD10L	WASHER

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AJS	DRAWING NO.	REV. 3
MFG. APPR.	N/A	DSI 9440	SHEET 3 OF 4
APPROVED	AJS	TITLE	SCALE
DE APPR.	AJS	WEARSHOE CHANGE	NTS
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QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

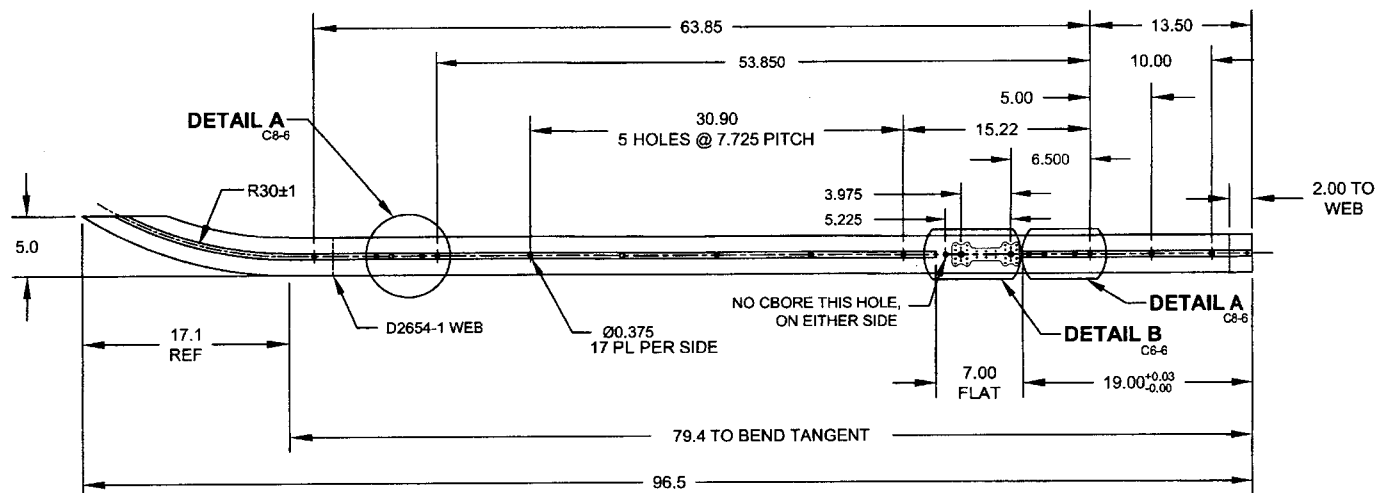
W/O 84479

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08-07-23-17

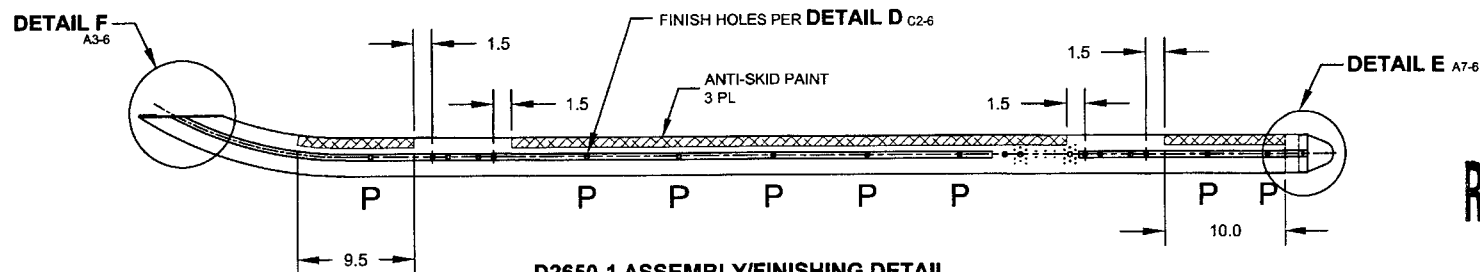
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG CW D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DEO9136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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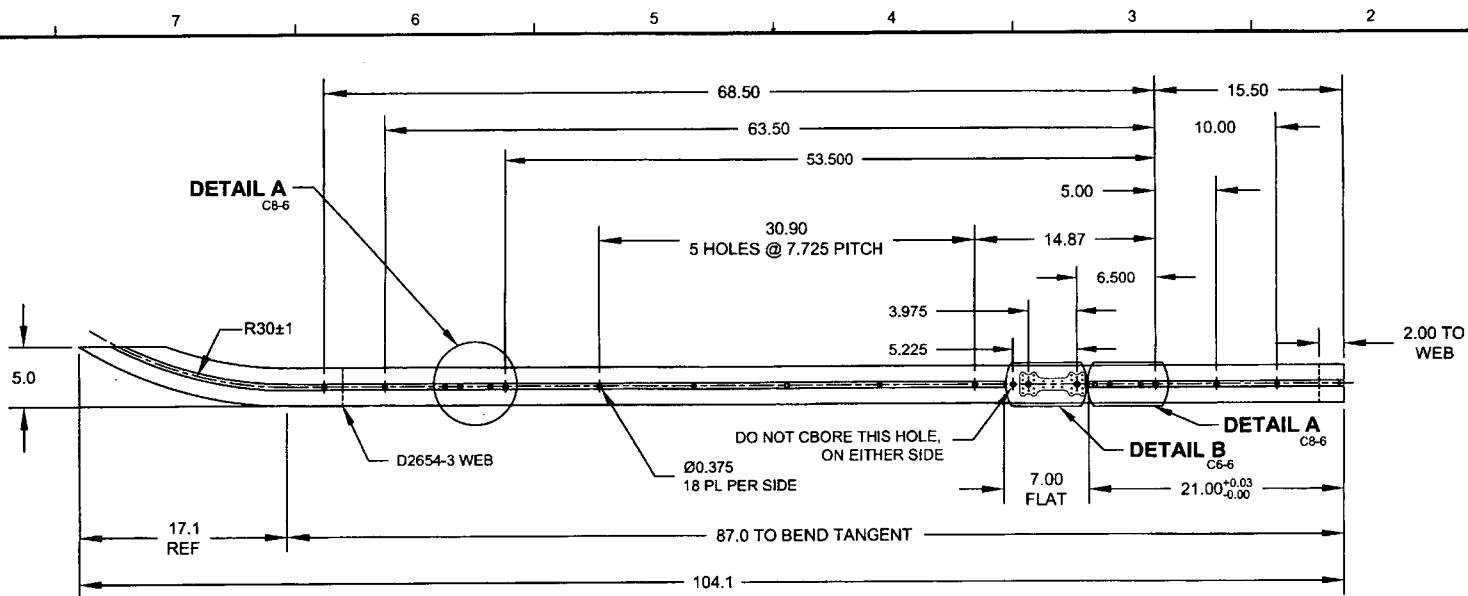
D2650-1 BENDING/DRILLING DETAIL



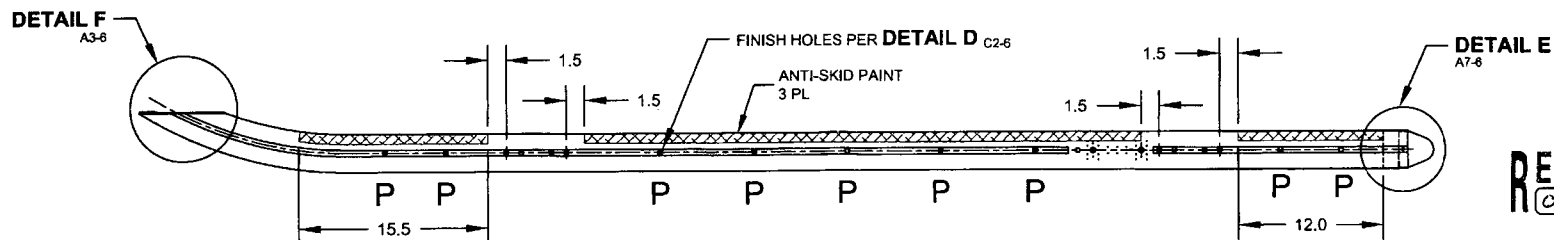
D2650-1 ASSEMBLY/FINISHING DETAIL

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820922/117

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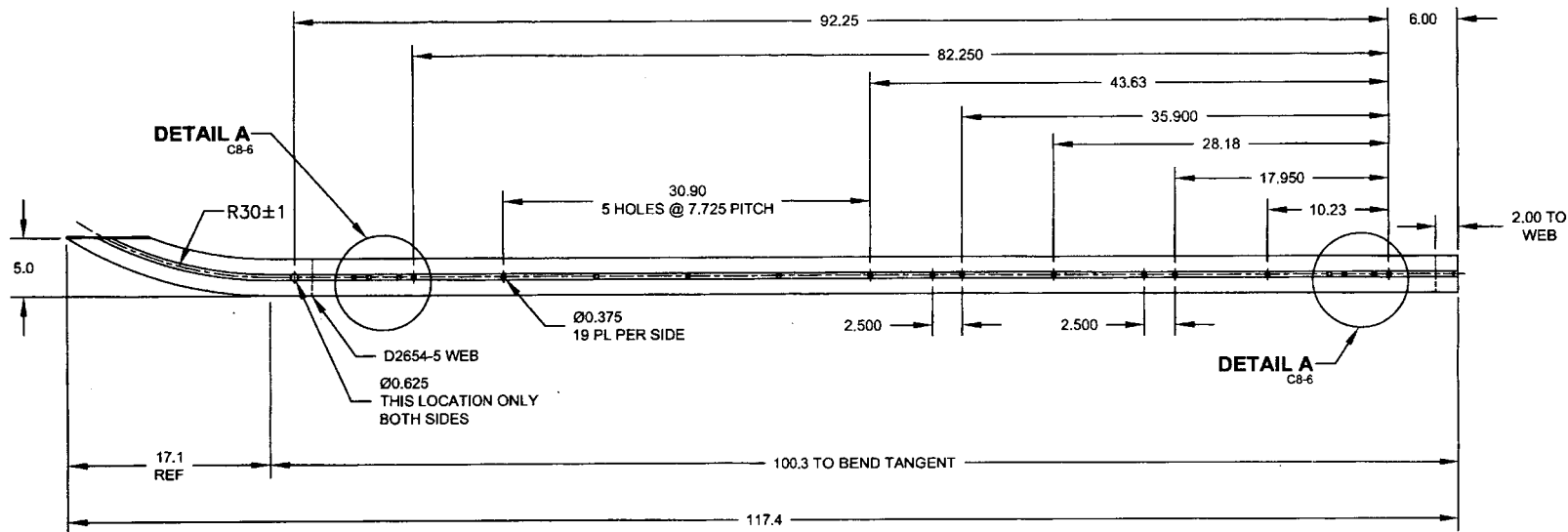


D2650-3 BENDING/DRILLING DETAIL

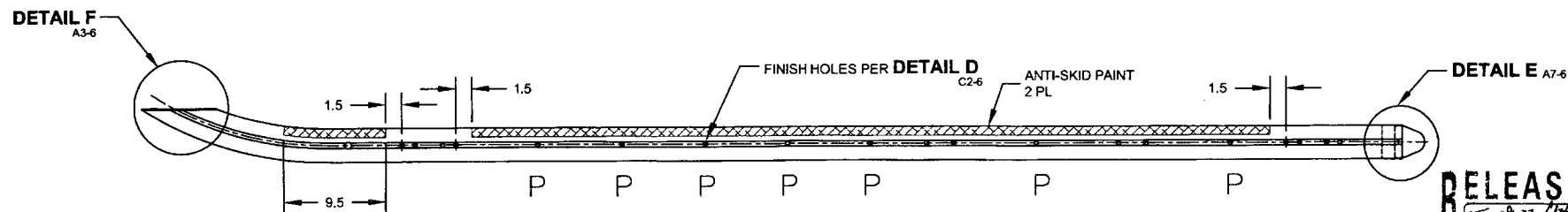


D2650-3 ASSEMBLY/FINISHING DETAIL

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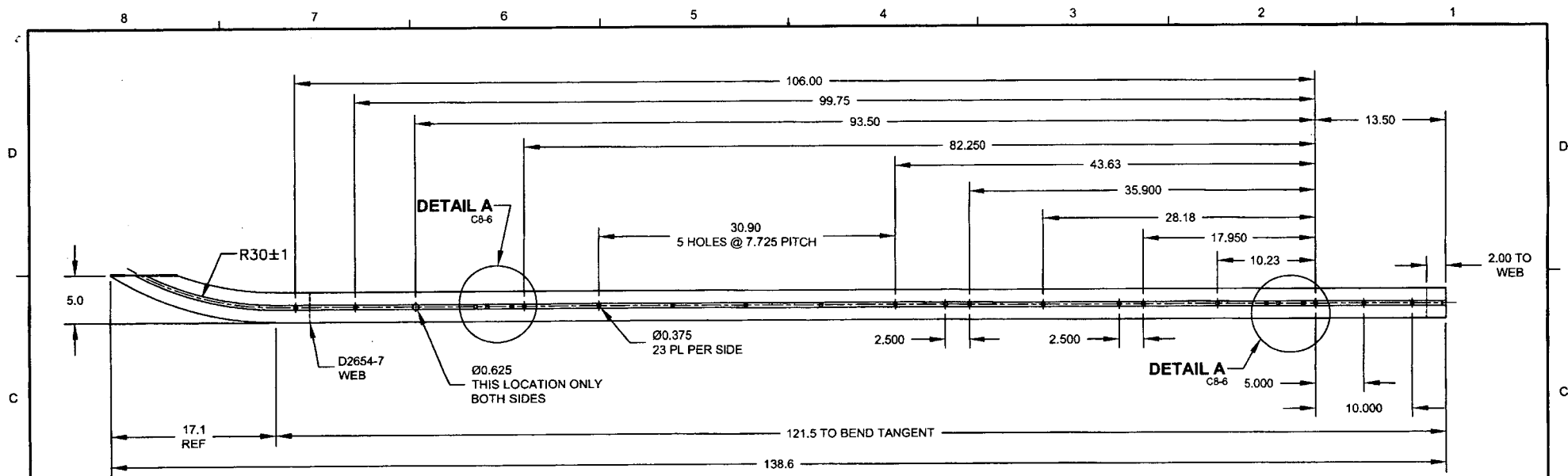
D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

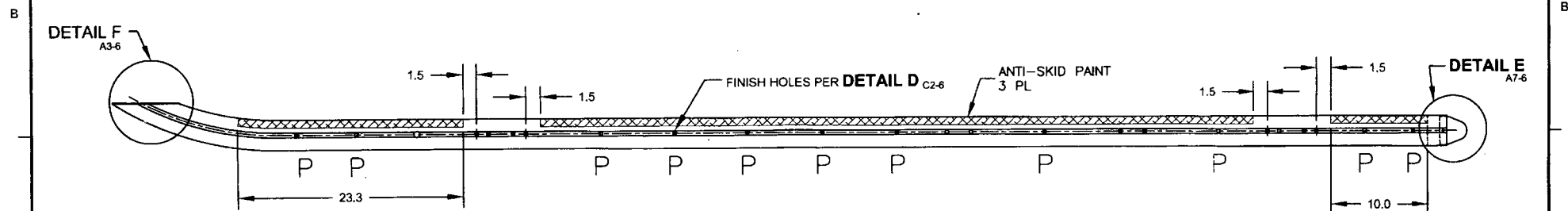
RELEASED
09-22-11

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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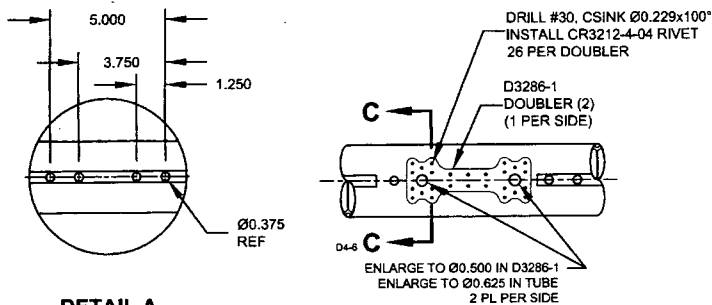
D2650-7 BENDING/DRILL DETAIL

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06 07 22



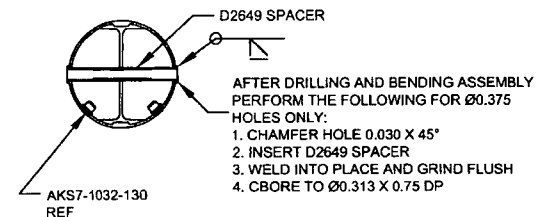
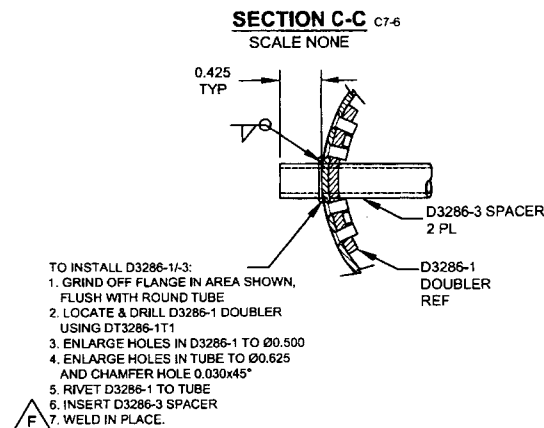
D2650-7 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
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MFG. APPR.		D2650	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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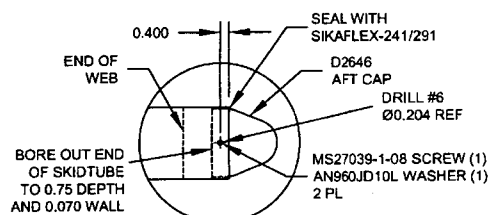


DETAIL A
SCALE 2X
C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5

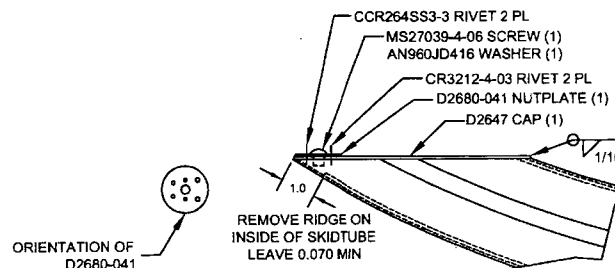
DETAIL B
SCALE 2X
C3-2
C3-3



DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X
B4-2
B4-3
B4-4
B4-5



DETAIL E
SCALE 2X
B2-2
B2-3
B1-4
B1-5



DETAIL F
SCALE NONE
B8-2
B8-3
B8-4
B8-5

DETAIL F NOTES:
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
08-09-22-13

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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